

Date: Wednesday, 8/15/2007 7:54:08 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR FWD RH
Job Number : 33898	
Estimate Number : 11234	
P.O. Number : N/A	Part Number : D32812
This Issue : 8/15/2007	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A C PRELIMINARY
First Issue : N/A	Drawing Revision : B LE 07.10.16
Previous Run : 30659	Material : N/A
Type : THERMOFORMING	Due Date : 8/22/2007
Written By : <u>[Signature]</u>	Qty: 10 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev A 04.07.01 New issue KJ/JLM	
Est Rev B 07.08.07 Thermoform in house DL	

**ENGINEERING  
APPROVAL**

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F6002 701 lexan black

POSITIVE  
RECALL

Comment: Qty.: 4.3600 sf(s)/Unit Total : 43.6000 sf(s)  
 lexan black .125"

Material Batch # M 103735M 105952

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



x8

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 07/10/25  
 DL 07/08/21 (x8) PTO

3.0 THERMOFORMING THERMOFORMING MACHINE



x8

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 008

Dwg. Rev. BFolio Rev. B

DL 07/08/22 (x8)  
 DL 07/10/25 (x10)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



DL 07/04/22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DL 07/10/25 (x10) x8-

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD RH

Job Number: 33898

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

DL 07.10.25 (10)

1) Trim to Finished Dimensions

BB 07-10-05

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

x8

1) Check Surface finish for undesired marks, voids, dimples etc.

DL 07.10.05 - PTD

2) Check dimensions to ensure conformity to drawing tolerances.

DL 07-10-25 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ed 07/11/05 (10)

POSITIVE  
RECALL

8.0

PACKAGING 1

PACKAGING RESOURCE #1



ENGINEERING  
APPROVAL



Comment: PACKAGING RESOURCE #1

07.10.29

20/11/09 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/11/12

(10)

Job Completion



DL 07.11.12

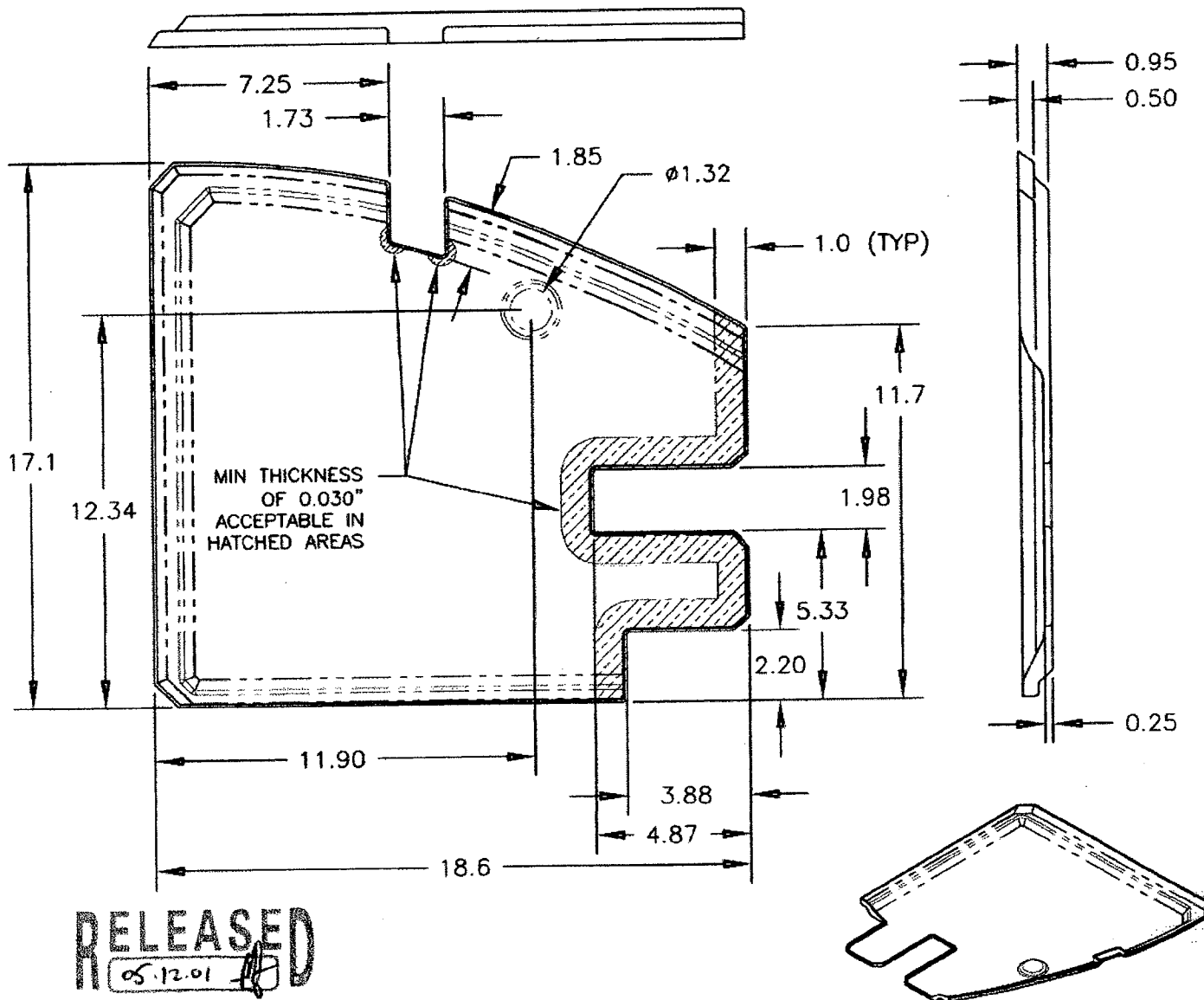
POSITIVE RECALL

EFFECTIVE 07.08.15 AUTH

RELEASED LE DATE 07.11.06



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	///	APPROVED	///	DRAWING NO. D3281 REV. B SHEET 1 OF 3
DATE	05.11.25	TITLE	FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE		
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED		



RELEASED  
05.12.01

### D3281-1 FLOOR PROTECTOR, FWD LH

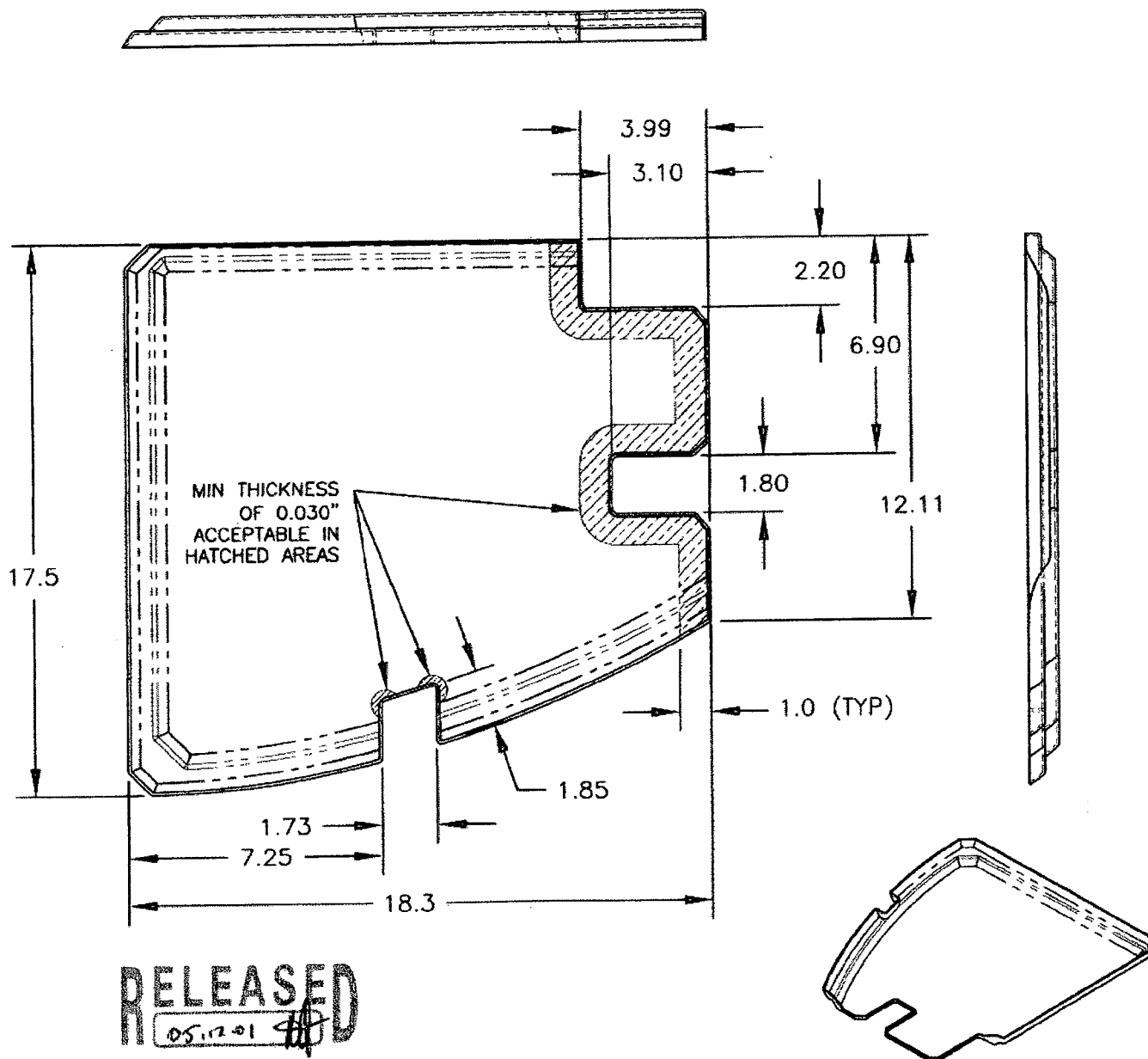
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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CHECKED <i>HL</i>	APPROVED <i>HL</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



**D3281-2 FLOOR PROTECTOR, FWD RH**

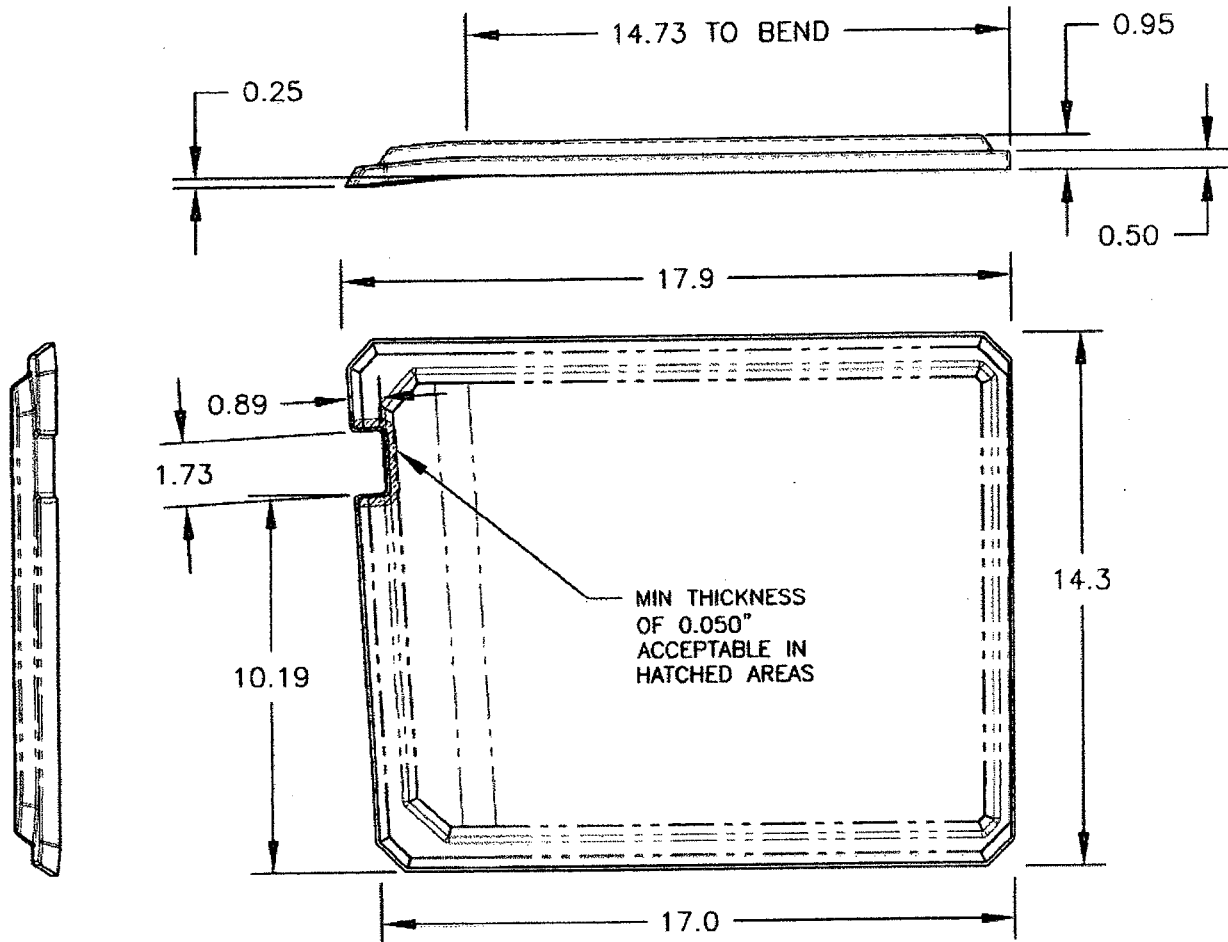
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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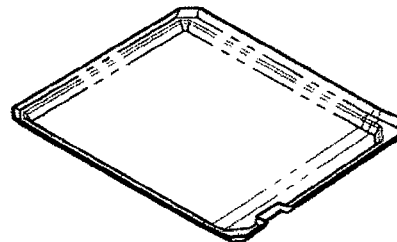
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CHECKED <i>ll</i>	APPROVED <i>ll</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED  
05.12.01. *ll*

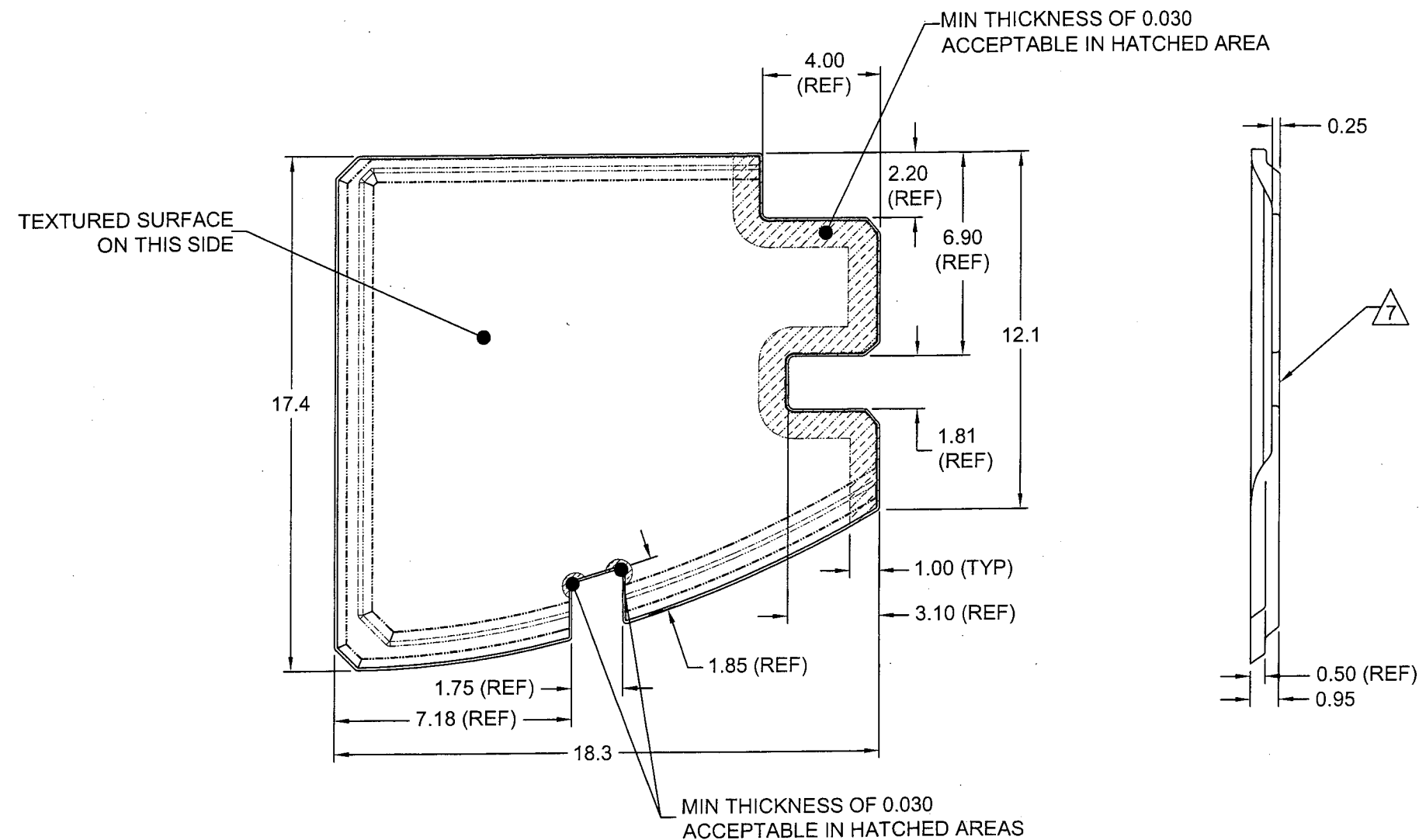


**D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**  
**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2  
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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**D3281-2 FLOOR PROTECTOR**

**D3281-2 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33898

**PRELIMINARY ISSUE**

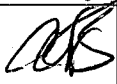



LE 07.16.16

DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	PE	DRAWING NO.	REV. C
MFG. APPR.	WJ	D3281	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.25	6.	8 parts not formed. enough. Material batch M103735	 07/11/25	Scrap & Replace.	07/10/25 2th.	 07/10/25	 07/11/25	 07/11/25

NOTE: Date & initial all entries

DART AEROSPACE LTD		WORK ORDER:	33898
Description: R44 Floor Protector Front RH		Part Number:	D3281-2
Inspection Dwg: D3281	Rev: <del>B</del>	Page 1 of 1	

*c preliminary*

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

(Step 4) Thermoforming  
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	WY
Acceptable shape definition	WY
Acceptable texture retention	WY
Free of visual flaws (bumps, cracks, voids, etc.)	WY

### (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev. ~~B~~ and record below *c preliminary*

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	.1	18.375	✓			
17.4	.1	17.435	✓			
12.1	.1	12.125	✓			
.95	.030	.956	✓			
.25	.030	.254	✓			

Measured by: *WY*  
Date: 07.10.25

Audited by: *[Signature]*  
Date: 7/10/25

Prototype Approval: *WY*  
Date: 07.10.25

Rev	Date	Change	Revised by	Approved
		New Issue		